



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5489-045
Job Sheet 193266



Part No: D5489-045

Job Qty: 12 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/10/19

Job Tracking No:

Due Date: 6/16/19

Created By: Shannon Hadley

Type: SOLD

Description:

Note: D5489 REV.B IPP REV:A 17.11.03 AS PER DWG REV.A DD VERF:JFS REV:B 18.05.06 PRELIM B7 DD
VERF:JFS IPP REV:C 18.08.15 AS PER DWG REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Waterjet - Flow - 1	12 pcs	5/16/19	5/16/19	0.00	4.00	Waterjet - Flow			DAS 69 9-89 6/28/19
110	QC 2	12 pcs	5/16/19	5/16/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			DAS 69 9-89 6/28/19
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			
							QC 2 - 64			



DART
AEROSPACE

Container No: S194692



Part: D5489 - 045
Job No: 193266
Serial No/Batch: S194692
Revision: B
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
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www.dartaerospace.com

Date: 07/19/19



Container No: S194692



Part: D5489-045

Job No: 193266

Serial No/Batch: S194692

Revision: B

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Date: 07/19/19

120 QC 8	12 pcs	5/16/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130 Small Fab - Brake NC - B4B	12 pcs	5/16/19	0.00 0.00	Small Fab - Brake - 1 - B4B	DAS JUL 02 2019 40 9-89
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	12 pcs	5/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
150 Automated Welding - B4B	12 pcs	5/16/19	0.00 4.00	Automated Welding - 1 - B4B	DAS 40 JUL 18 2019 9-89 M✓
160 QC 10	12 pcs	5/16/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
170 QC 5	12	5/16/19	0.00 0.00	QC 10 - 9	
				QC 5 - 10	

	pcs				QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	2
					QC 5 - 30	
					QC 5 - 40	
180 Handfinish - 4-1-Assembly-B4B	12 pcs	5/16/19	0.00 4.00		Handfinish - 4 - 1 - B4B	
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	AL 19-7-19
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
190 QC 3	12 pcs	5/16/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
200 Packaging 3-1 - Stock - B4B	12 pcs	5/16/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	DL Bin: ST 602
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	

Mon 7-22-2019 →

				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	12 pcs	5/16/19	0.00 0.00	QC 21 - SA - 21	DAG JUL 22 2019
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-85
Part Op 100 - 1-Cut as per Dwg (D5489-5) Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Form as per dwg) 140 - (QC5- Inspect part completeness to step on W/O) 150 - ***SEE NOTE 8,9 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: _____ 160 - (QC10- Inspect visual per QSI004- ground welds) 170 - QC5- Inspect part completeness to step on W/O) 180 - (Assemble as per dwg) COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG AND PER QSI005 A/R ROCKGUARD BATCH: <u>5184717</u> 190 - (QC3- Inspect Part Finish) 200 - (Identify as per dwg & Stock Location: _____) LOCATION : FP002 210 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S16GA	304/316 Sheet .063	24 sf (2 ea)	100-Waterjet - Flow - 1	5199460	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M304S16GA	24	270	0	
Part Specifications					
Specifications could not be found.					



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D5489-045 Job Sheet 193221



Part No: D5489-045

Job Qty: 12 ea

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No: 13643

Due Date: 5/16/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: D5489 REV:B IPP REV:A 17.11.03 AS PER DWG REV:A DD VERF:JFS REV:B 18.05.06 PRELIM B7 DD
VERF:JFS IPP REV:C 18.08.15 AS PER DWG REV:B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		5/16/19	0.00	4.00	Waterjet - Flow		
110	QC	12 pcs		5/16/19	0.00	0.00	QC2 Waterjet-4		
120	QC	12 pcs		5/16/19	0.00	0.00	QC8-6		
130	Brake NC	12 pcs		5/16/19	0.00	2.40	Brake NC 1		
140	QC	12 pcs		5/16/19	0.00	0.00	QC5		
150	Automated Welding - B4B	12 pcs		5/16/19	0.00	4.00	Automated Welding - 1 - B4B		
160	QC	12 pcs		5/16/19	0.00	0.00	QC10		
170	QC	12 pcs		5/16/19	0.00	0.00	QC5		
180	HandFinish	12 pcs		5/16/19	0.00	4.00	HandFinish4		
190	QC	12 pcs		5/16/19	0.00	0.00	QC3		
200	Packaging	12 pcs		5/16/19	0.00	0.00	Packaging3-2		
210	QC21-SA	12 Ea		5/16/19	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg (D5489-5) Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary
Descriptions: 150 - ***SEE NOTE 8,9 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED
WELDING USE 8259 HARDCOAT BATCH: _____
180 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG AND PER QSI005 A/R
ROCKGUARD BATCH: _____
200 - LOCATION : FP002

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	24 sf (2 ea)	100-Waterjet - Flow - 1	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	24	270	0
Part Specifications				
Specifications could not be found.				

Plex 4/9/19 1:50 PM Dart.Macdonald.Dara

DART AEROSPACE LTD		Work Order: 193266
Description: wearplate Assembly		Part Number: 05489-045
Inspection Dwg:	Rev: B	Page 1 of 1

INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC						
0.400	+/- 0.010	0.398			VDE-02	
0.500	+/- 0.010	0.498				
0.460	+/- 0.010	0.458			Tape	
0.620	+/- 0.010	0.619				
0.188	+/- 0.005 -/0.001	0.189				
3.50	+/- 0.030	3.51				
7.84	+/- 0.030	7.85				
4.31	+/- 0.030	4.32				
15.50	+/- 0.030	15.55				
11.00	+/- 0.030	11.00				
2.44	+/- 0.030	2.43				
20.20	+/- 0.030	20.22				
28.37	+/- 0.030	28.37				
36.40	+/- 0.030	36.42				
38.07	+/- 0.030	38.07				
Manual Milling						
2.50	+/- 0.030	2.503	1			

Measured by: JRB	Audited by: DAS 40 9-89	Preliminary Approval:
Date: 6/27/19	Date: JUL 02 2019	Date:
Rev	Date	Change
A	14.07.14	New Issue
Revised by		Approved
KJ		



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Part: D5489-045

Job No: 193266

Serial No/Batch: S194692

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/28/19